

Work Order ID 52818

October 15, 2009 9:40:56 AM



Page 1

Item ID: D3145-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plant

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Draw Nbr	Revision Nbr
D3145	Rev B

100



BAND SAW

Bandsaw

Memo

0.00

0.00

Jeaspa Bandsaw

Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per Folio FA318 and Dwg D3145!Deburr and Tumble

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

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Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC8- Inspect parts - second check

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 9:00 OVEN TEMPERATURE:
325° FINISH TIME: 9:30

Work Order ID 52818

October 15, 2009 9:40:57 AM



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Item ID: D3145-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W *8/11/09*

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

for Helicorp PTY *0.00*
order # 4461

9/11/09 *SP*

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/09 *D*

W *8/11/09*

Picklist Print

Page 1

October 15, 2009 9:40:55 AM

Work Order ID: 52818



Parent Item: D3145-2RevB



Parent Item Name: Bracket

Start Date: 10/15/09

Required Date: 10/19/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	13.3259	0.4035			

6061-T6 Bar 2.00 x 2.00



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	13.32586316	
110167	0.532	
13085	10.903	
17124	1.89086316	

0.4035 DR 09/10/19

DART AEROSPACE LTD	Work Order:	S2810
Description: Bracket	Part Number:	D3145-2
Inspection Dwg: D3145	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JL</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	09/10/19	Date:	09.10.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	[Signature]

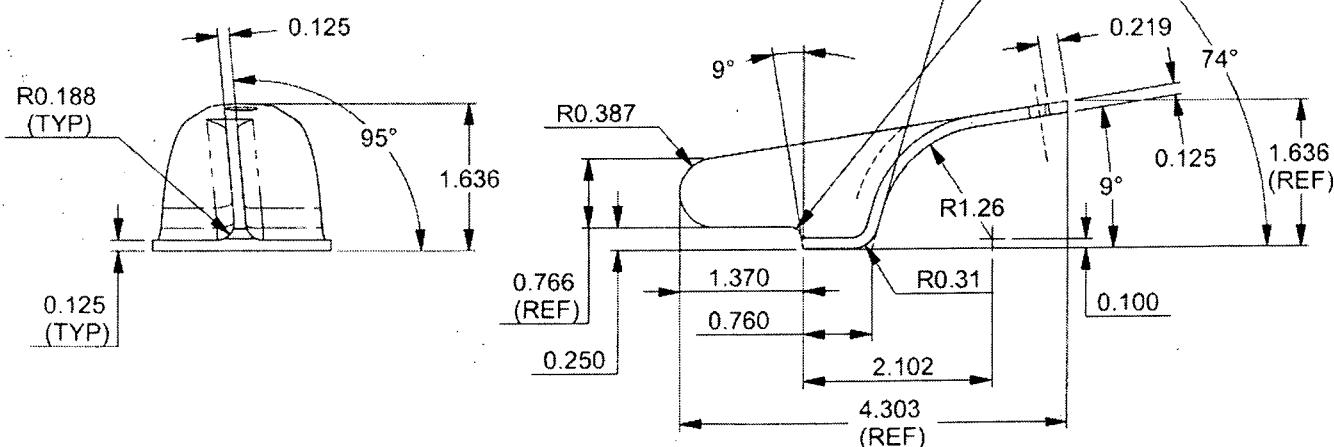
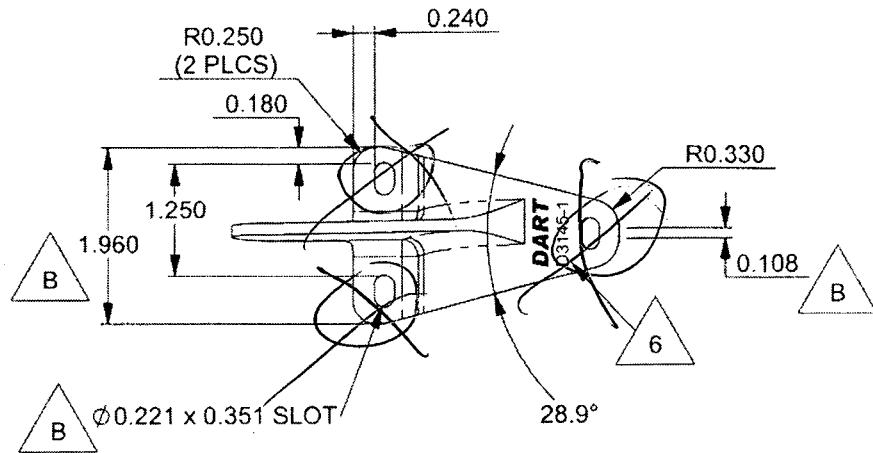
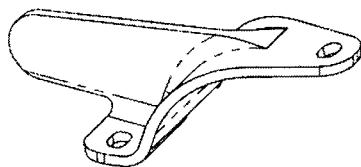
Rabin M052818

DART



DESIGN <i>KF</i>	DRAWN BY <i>SP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06	TITLE BRACKET	SCALE 1:2	

A	02.04.24	NEW ISSUE
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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